

Work Order ID 77324-2

December 2, 2011 1:14:11 PM

77324

Page 1

Item ID: D3215-3

Revision ID:

Item Name: Webbing Tidy

Start Date: 12/02/11 Start Qty: 60.00

Required Date: 12/07/11 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: *cy*

QC:

Date: 11/21/12 Tooling:

Date:

SPC (Y/N):

Date:

Date:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3215	Rev D
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100

100

Waterjet

FLOW CNC Waterjet

855, 046

FLOW WATER JET

Memo

1-Cut as per Dwg D3215 (D3215-3A)

Rev: *D* 2-Deburr if necessary

Dwg Rev: *D* Prog

3-Identify as D3215-3A

0.00

0.00

11-12-5

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

11-12-5

(cc)

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Sub 2/05

route
(H100)

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Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

1-Cut D3215-3B (2.130" x 0.530") as per dwg D32152-Deburr3-Identify as D3215-3B

0.00

11/12/06 *100*

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.12/07

counted
(+100)
-D3215-2's
only

150

150

Brake NC

Brake NC

NC BRAKE

0.00

Memo

Form D3215-3A as per Dwg D3215

0.00

11/12/06

(94)

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Start Date: 12/02/11 Start Qty: 60.00

Required Date: 12/07/11 Req'd Qty: 60.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

160

160

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Schulz

waters
(x24)

Phc →

170

170

Large Fab

Large Fab

Large Fab

Memo

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI
004A/R AL ROD BATCH *MW4514* Identify as D3215-
3Grind flush

0.00

0.00

X32 11-12-13 JDL

180

180

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

X32 11-12-13 JDL

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Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

8/11/13

counted
732

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

32 x 8 m-f 11/12/14

210

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

210

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

4:00

3200F

4:30

32 x 8 m-f 11/12/14

11/5/128

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Webbing Tidy

Start Date: 12/02/11 Start Qty: 60.00

60

Cust Item ID:

Required Date: 12/07/11 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

220

QC3- Inspect Part Finish

0.00

220

32 BK 11-12-16

QC

Memo

0.00

Quality Control

230

Packaging

0.00

230

41

Packaging

Memo

0.00

Packaging

11/12/20 [Signature]

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

11/12/20 [Signature]

11-12-20 (32)

Picklist Print

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Work Order ID: 77324
Parent Item: D3215-3
Parent Item Name: Webbing Tidy

Start Date: 12/02/11
Start Qty: 60.00

Required Date: 12/07/11
Required Qty: 60.00

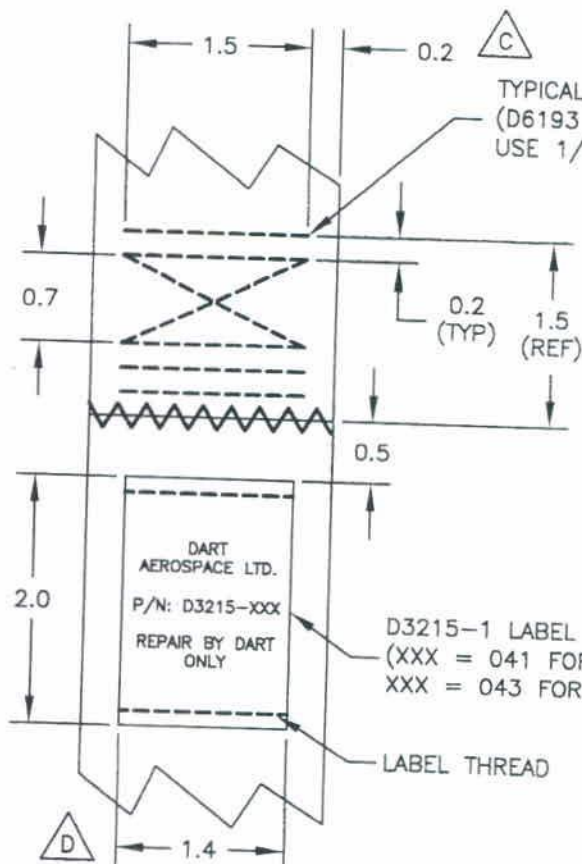
Comments: IPP A 04.01.06 New issue KJ/RF
IPP Rev:B Now on Waterjet 06-07-03 JLM
IPP rev C ecn 940 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040 5052-H132 .040 Sheet		Purchased	No			100	sf	84.3000	0.008	0.5052632			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		84.3							
				117130		5.8							
				119384		78.5							
M5052H32S.040 5052-H132 .040 Sheet		Purchased	No			130	sf	84.3000	0.0258	1.6294737			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		84.3							
				117130		5.8							
				119384		78.5							

Handwritten notes and signatures:
 12/11/11
 0.8
 2.5
 119384
 100

DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27	TITLE HARNESS ASSEMBLY		SCALE 3:2

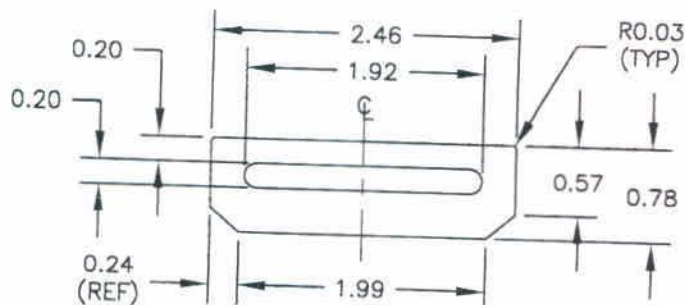
**VIEW A-A****D3215-1 LABEL:**

- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

RELEASED07 06 07 *[Signature]***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

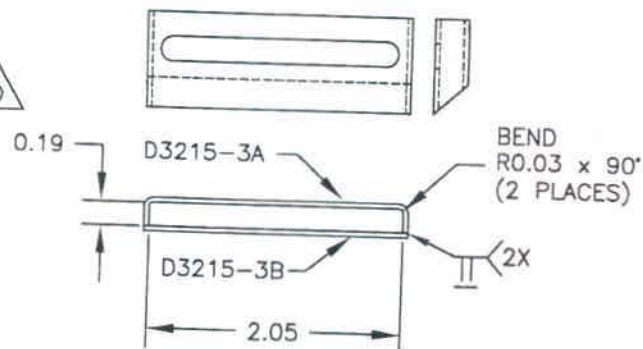
TYPICAL STITCHING PATTERN
(D6193 TYPE 301, 7-10 STITCHES PER IN.
USE 1/2 MIN. BACKSTITCH, NO LOOSE THREADS)



D3215-3A FLAT PATTERN
R0.03 (TYP)

D3215-3B**D3215-3A/-3B NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3

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